

Work Order ID 68112

Wednesday, April 06, 2011 2:39:48 PM



Next week
April 14th

Page 1

Item ID: D4293-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 4/7/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MP

Date: 11-04-06

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4293

C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

B.A 11/04/13

2

φ

Jeaspa Bandsaw

Cut Blank to 6.850"

Batch: 116930

GRAIN ALONG 4"**

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

B.A 11/04/13

2

φ

HAAS CNC vertical machine #1

1-Machine per folio FB005

DWG REV: C

FOLIO REV: AA

2- deburr rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B.A 11/04/13

2

Ø

121

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

DRILL & TAP FOR HELICOIL AS PER DWG

B.A 11/04/15

2

Ø

122

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B.A 11/04/15

2

Ø

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Wednesday, April 06, 2011 2:39:48 PM



Page 3

Item ID: D4293-1

Accept



Setup Start



Revision ID:

Item Name: Fitting

Stop



Start Date: 4/7/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		11/4/18					
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
145 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M116 984 Memo MASK THREADED HOLE	0.00 0.00							

11/4/18

2 BL 11-4-18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 4

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Start Date: 4/7/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

146

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 6 11/04/18

148

0.00



Small Fab

Memo

0.00

Small Fab

INSTAL HELICOIL AS PER DWG

=> m-l 11/04/18

(2X)

149

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/04/18

(72)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 5

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Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: ST 48

0.00



Packaging

Memo

0.00

Packaging

11/4/12

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/19 11/4/19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 06, 2011 2:39:43 PM

Page 1

Work Order ID: 68112

Parent Item: D4293-1

Parent Item Name: Fitting



Start Date: 4/7/2011

Required Date: 4/14/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-11-15 JLM VERIFIED BY:DD IPP REV
B: AS PER REV B 11-02-15 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21209F1-10

Purchased

No

Each

94.0000

2



HELI COIL



M-L 11/04/18

Location

Loc Qty

Loc Code

ST305

94

116977 ✓

94

2X

M7075T73B4.000x4.00

Purchased

No

f

20.2810

1.2

0



7075-T73 Bar 4.0 x 4.0

Location

Loc Qty

Loc Code

MAT005

20.281

116153

0.75

116324

7.95

116764

6

116867

0.041

✓116930

5.54

1.1600 +1

MA 11/04/13

11

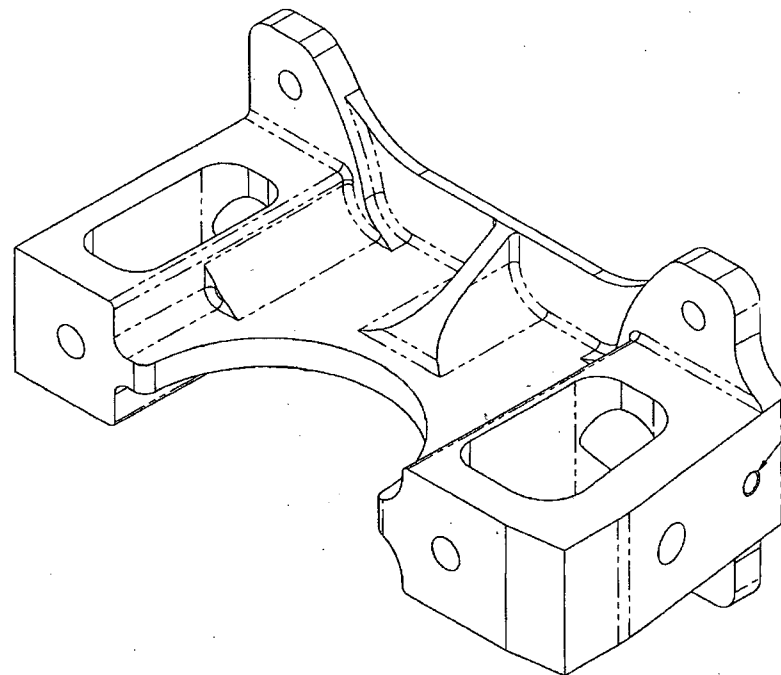
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



MS21209F1-10 HELICAL COIL, 1X
REF

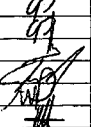
GRAIN
DIRECTION

D4293-1 FITTING

RELEASED
2011-02-01

NOTES:

- 1) MATERIAL: 7075-T73/-T7351/-T73510/-T73511 BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4293-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.18 lbs

C	ADD HELICAL COIL (D1-2, B4-3)	CP	11.01.14
B	0.800 WAS 0.78 (C8-2). 1.730 WAS 1.72 (C4-2)	CP	10.11.30
A	NEW ISSUE	CP	10.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D4293	REV. C
MFG. APPR.		TITLE	SHEET 1 OF 3
APPROVED		FITTING (206L AFT)	SCALE
DE APPR.			NTS
DATE	11.01.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

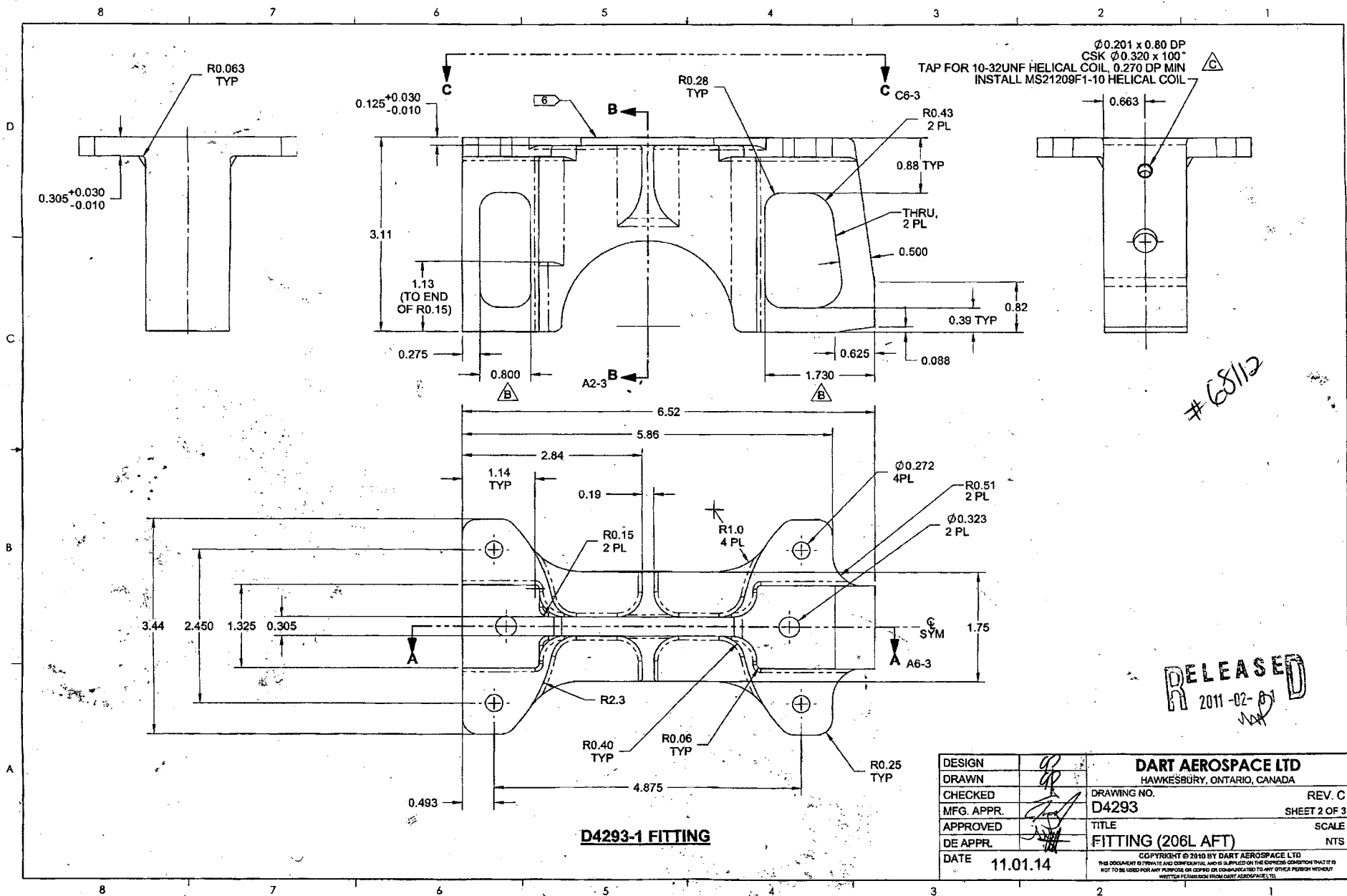
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NOTE: Date & initial all entries



RELEASED
2011-02-01

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4293	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FITTING (206L AFT)	NTS
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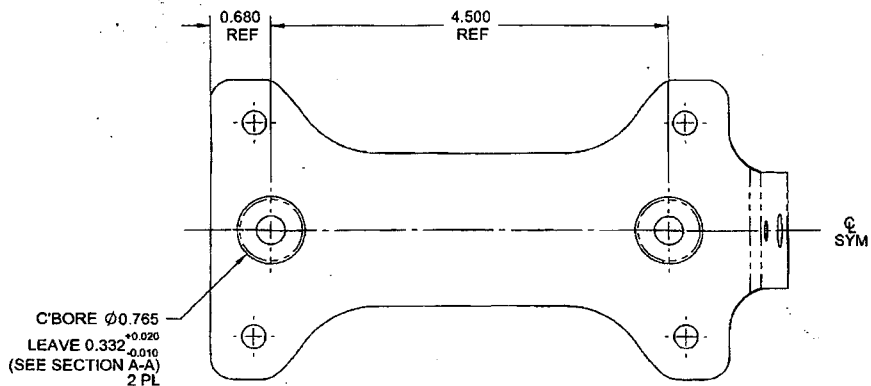
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

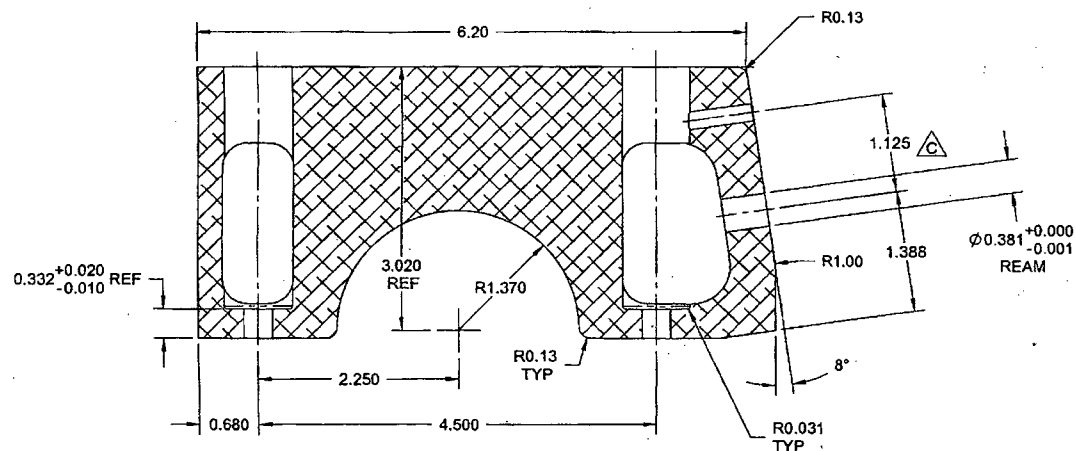
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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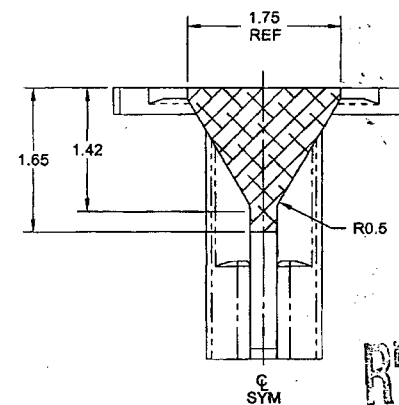
8 7 6 5 4 3 2 1



SECTION C-C D3-2



SECTION A-A A3-2



SECTION B-B C5-2

RELEASED
2011-02-11

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4293
MFG. APPR.		REV. C
APPROVED		SHEET 3 OF 3
DE APPR.		TITLE FITTING (206L AFT)
DATE	11.01.14	SCALE NTS

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8 7 6 5 4 3 2 1

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DART AEROSPACE LTD		Work Order: 68112
Description: FITTING		Part Number: D4293-1
Inspection Dwg: D4293 Rev: C		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.305	+0.030/-0.010	0.309	✓		Vern	GA-01
R0.063	+/-0.010	R0.063	✓		R-6	ref.
0.125	+0.030/-0.010	0.128	✓		Vern	GA-01
1.13	+/-0.030	1.132	✓		"	"
3.11	+/-0.030	3.119	✓		"	"
0.275	+/-0.010	0.273	✓		"	"
0.800	+/-0.010	0.794	✓		"	"
1.730	+/-0.010	1.722	✓		"	"
0.625	+/-0.010	0.635	✓		"	"
0.088	+/-0.010	0.090	✓		DG	GA-03
0.39	+/-0.030	0.391	✓		"	"
0.82	+/-0.030	0.820	✓		"	"
0.500	+/-0.010	0.493	✓		"	"
0.88	+/-0.030	0.884	✓		"	"
3.44	+/-0.030	3.444	✓		"	"
2.450	+/-0.010	2.450	✓		"	"
1.325	+/-0.010	1.327	✓		"	"
0.305	+/-0.010	0.300	✓		"	"
1.14	+/-0.030	1.140	✓		"	"
2.84	+/-0.030	2.835	✓		HG	31006
5.86	+/-0.030	5.870	✓		Vern	GA-01
6.52	+/-0.030	6.525	✓		Vern	CNC-02
φ0.272	+0.006/-0.001	φ0.278	✓		Vern	GA-01

Measured by: H.A.
Date: 11/04/14

Audited by: SA
Date: 11/4/18

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	


DART AEROSPACE LTD		Work Order: 68112
Description: FITTING		Part Number: D4293-1
Inspection Dwg: D4293 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.323	+0.006/-0.001	Ø 0.327	✓		Vern	GA-01
0.19	+/-0.030	0.187	✓		"	"
1.75	+/-0.030	1.756	✓		"	"
4.875	+/-0.010	4.875	✓		"	"
0.493	+/-0.010	0.496	✓		"	"
0.663	+/-0.010	0.665	✓		Vern	GA-01
4.500	+/-0.010	4.499	✓		"	"
Ø 0.765	+0.010/-0.001	Ø 0.765	✓		"	"
0.332	+0.020/-0.010	0.339	✓		"	"
0.680	+/-0.010	0.680	✓		"	"
2.250	+/-0.010	2.250	✓		"	"
R0.031	+/-0.010	R0.032	✓		R-G	ref.
8°	+/- 1/2°	8°	✓		Angle protector	MLL - CBB
1.388	+/-0.010	1.390	✓		Vern	GA-01
Ø 0.381	+0.000/-0.001	Ø 0.3805	✓		"	"
1.125	+/-0.010	1.125	✓		"	"
R0.13	+/-0.030	R0.125	✓		R-G	ref
6.20	+/-0.030	6.198	✓		Vern	GA-01
1.65	+/-0.030	1.652	✓		"	"
1.42	+/-0.030	1.430	✓		"	"
Ø 0.320 x 100°	+/-0.010	0.325	✓		"	"

Measured by: G.A.
Date: 11/04/14

Audited by: 
Date: 11/4/18

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

